

17/09

Dart Aerospace Ltd.

Date: Tuesday, 9/11/2007 10:57:03 AM
 User: Chantal Lavoie

Process Sheet

Customer	: N/A	Drawing Name	: DOUBLER
Job Number	: 34546		
Estimate Number	: 12960		
P.O. Number	: N/A	Part Number	: D36422
This Issue	: 9/11/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3642 UNDER REVIEW
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: U/R
Written By	: <u>W</u>	Material	: N/A
Checked & Approved By	: <u>W</u>	Due Date	: 9/18/2007
Comment	: Est Rev:A New Issue 07-07-20 JLM	Qty:	24 Um: Each
	Verified By: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.1747 sf(s)/Unit Total: 4.1933 sf(s)

2024-T3 .050 sheet

Batch: M105646 B 07-09-19

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3642

Dwg Rev: A B 07-09-19

Prog Rev: A

2-Deburr if necessary B 07-09-19

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 07-09-19

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

E 07-09-19

count

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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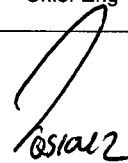
Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 07-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/22	#50	one part lost Dummy Aladin R.C. Hammer error	 05/10/22	consider part screen. was lost from inspection to Aladin	BL 07/09/20	En 07/10/22	 05/10/22	En 07/10/22

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:57:03 AM
User: Chantal Lavoie

Process Sheet

Customer:

Drawing Name: DOUBLER

Job Number: 34546

Part Number: D36422

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Er A/09/20 (424) center

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: _____

3/10/15 SP

ENGINEERING APPROVAL 16
24X 07/10/15

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

24
D 07/10/15

Job Completion



2207-1016

CRITIQUE RECALL

EFFECTIVE

07/09/11

AUTH

U

RELEASED

16

DATE

07/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

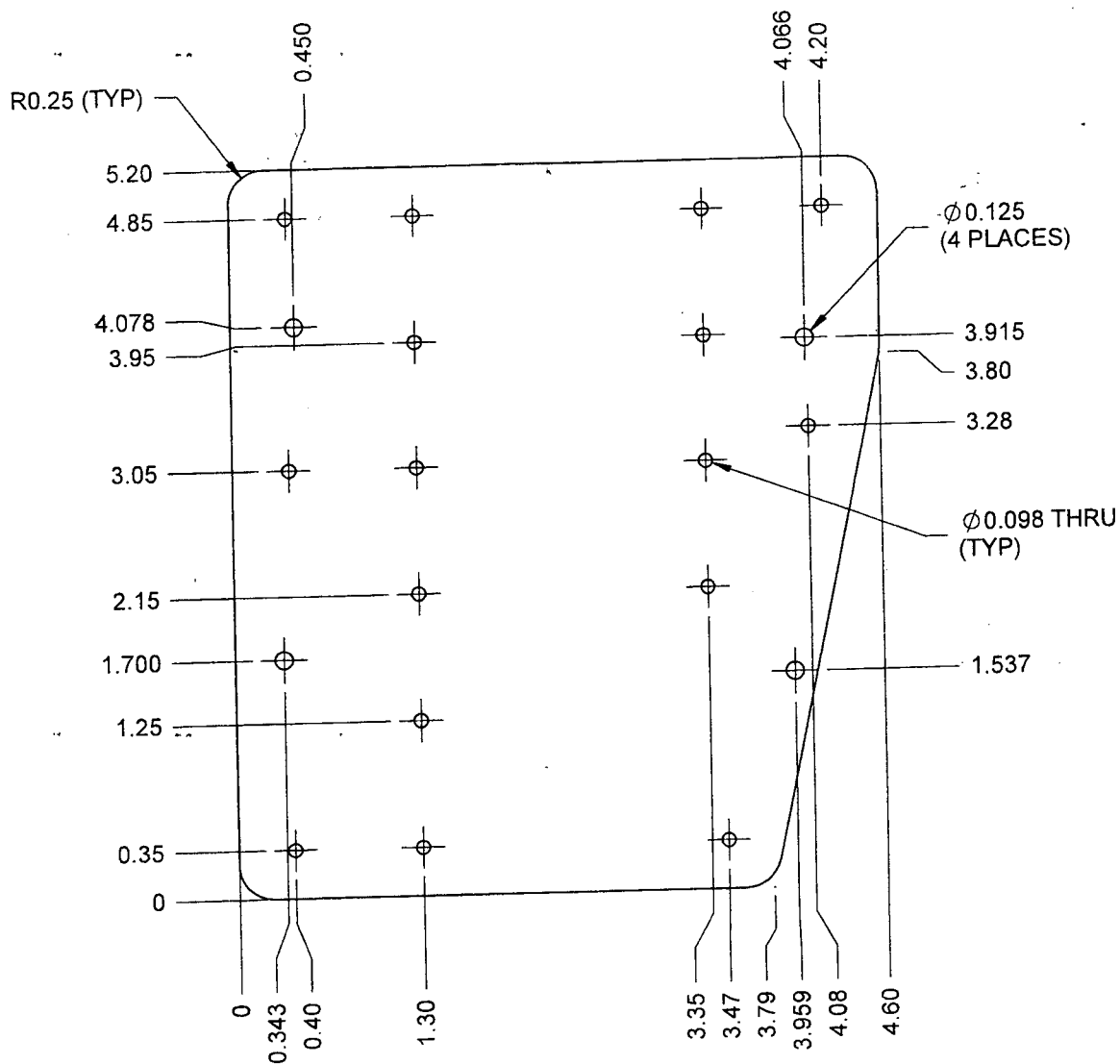
NOTE: Date & initial all entries

7

6

5

4



D3642-1 DOUBLER (WAS GENEVA P/N G10607-1)
D3642-2 OPPOSITE (WAS GENEVA P/N G10607-2)

w/o 34546

AL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037
 (REF DART SPEC M2024T3S.050)

CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 FINISHES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 FINISHES UNLESS OTHERWISE NOTED

SHARP EDGES: 0.005 TO 0.010 MAX
 IDENTIFICATION: IDENTIFY WITH DART P/N "D3642-1/-2" USING FINE POINT PERMANENT INK MARKER.

WEIGHT: 0.11 lbs

8

7

6

5

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 34546
Description: DOUBLER		Part Number: D3642-2
Inspection Dwg: D3642 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .125	+ .005 - .001	.125	*			
Ø .098	+ .004 - .001	.98	*			
5.20	+/- .030	5.20	*			
4.85	+/- .030	4.85	*			
4.078	+/- .010	4.078	*			
3.95	+/- .030	3.95	*			
3.05	+/- .030	3.05	*			
2.15	+/- .030	2.15	*			
1.700	+/- .010	1.700	*			
1.25	+/- .030	1.25	*			
.35	+/- .030	.35	*			
.450	+/- .010	.450	*			
.343	+/- .010	.343	*			
.40	+/- .030	.40	*			
1.30	+/- .030	1.30	*			
3.35	+/- .030	3.35	*			
3.47	+/- .030	3.47	*			
3.79	+/- .030	3.79	*			
3.959	+/- .010	3.959	*			
4.08	+/- .030	4.08	*			
4.60	+/- .030	4.60	*			
4.066	+/- .010	4.066	*			
4.20	+/- .030	4.20	*			

Measured by: RB	Audited by: ER	Prototype Approval: UE
Date: 07-09-19	Date: 07/09/19	Date: 07-09-19

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	